

Work Order ID-66884

Wednesday, March 02, 2011 8:06:41 AM



Page 1

Item ID:	D4034-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Aft Upper Rib Assembly					
Start Date:	3/2/2011	Start Qty:	3.00		Cust Item ID:	
Required Date:	3/7/2011	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-2	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4034	B

100 Weld per dwg A/R S.S. rod Batch: 115928 0.00



Large Fab Memo 0.00

Large Fab 1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

CP 11-03-15

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

BE 11-03-15

3

120 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

11 03 16 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66884

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Wednesday, March 02, 2011 8:06:41 AM

Item ID: D4034-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Upper Rib Assembly

Start Date: 3/2/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location:

B/C

0.00

Memo

0.00

Packaging

Pl 11-03-15

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/3/23 DJ

mf
11-03-23

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, March 02, 2011 8:06:47 AM

Page 1
T

Work Order ID: 66884

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 3/2/2011


Required Date: 3/7/2011

Start Qty: 3.00

Required Qty: 3.00


Comments: IPP Rev:A: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER
DWG REV.B DD VERF:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4034-1  Rib		Manufactured	No			100	Each	8.0000	1	3			
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Location Loc Qty Loc Code


WA	8	
66108	2	
66603	6	

D4034-3  Rib		Manufactured	No			100	Each	0.0000	1	3			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4021-7  Hoop		Manufactured	No			100	Each	11.0000	1	3			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

WA	11	
58039	1	
66420	4	
66618	6	

D4021-9  Bushing		Manufactured	No			100	Each	80.0000	4	12			
--	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Location Loc Qty Loc Code

WA	80	
56094	2	
65363	5	
65924	9	
66437	64	

Cpl 11.03.15

3

366617 → 3

Cpl 11.03.15

Cpl 11.03.15

Cpl 11.03.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

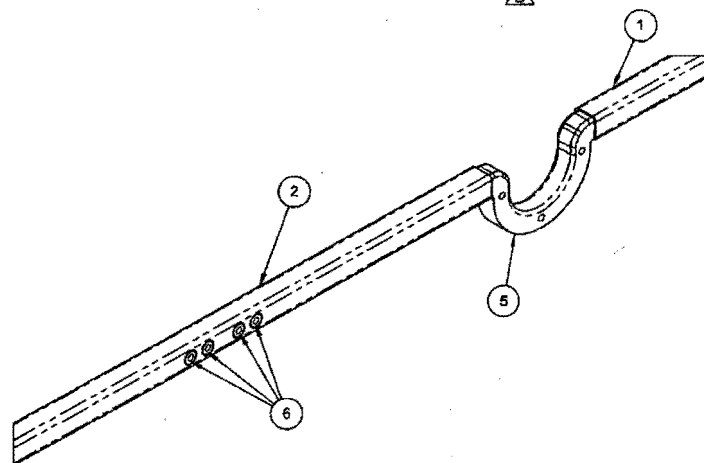
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

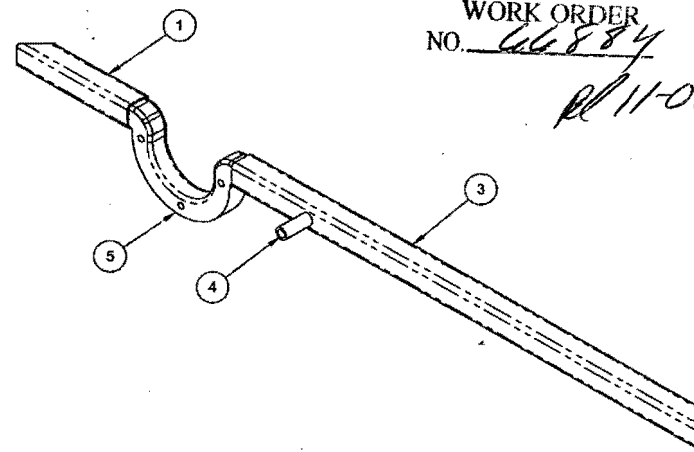
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66884
R11-03-2

RELEASED
2011-01-18
JM

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

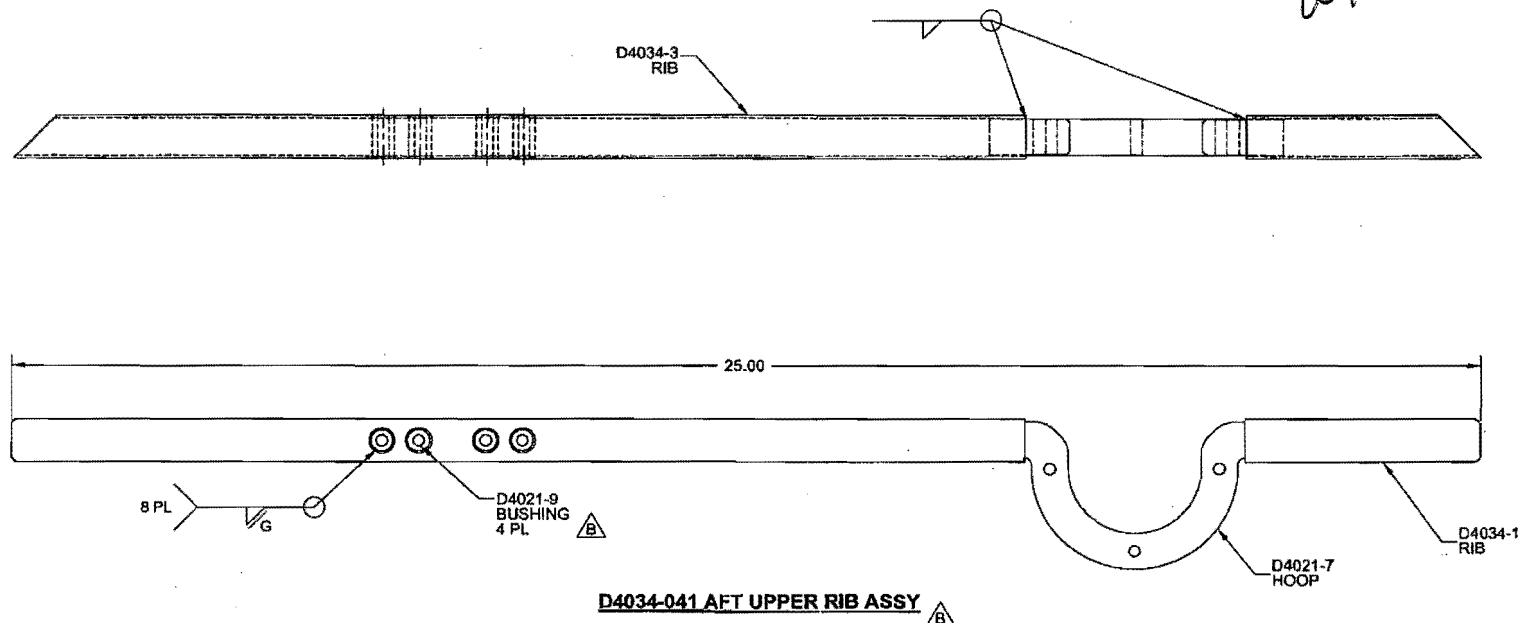
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O 66884



RELEASED
2011-01-18

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.61 lbs
 - 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 2 OF 4
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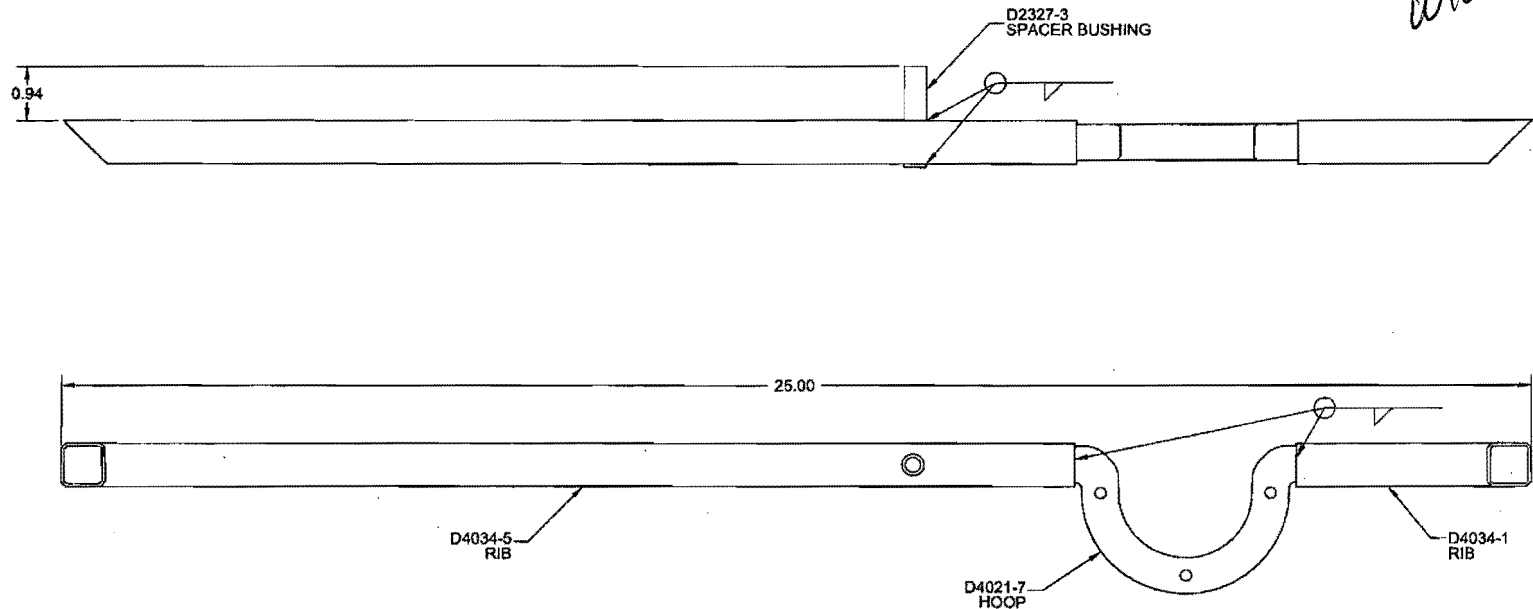
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ULO 66884



D4034-043 FWD UPPER RIB ASSY

RELEASED
2011-01-18

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.58 lbs
 - 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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Dart Aerospace Ltd

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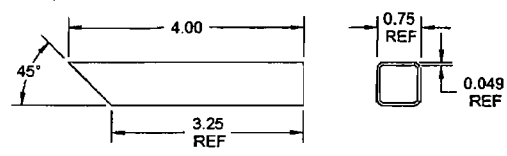
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

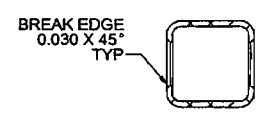
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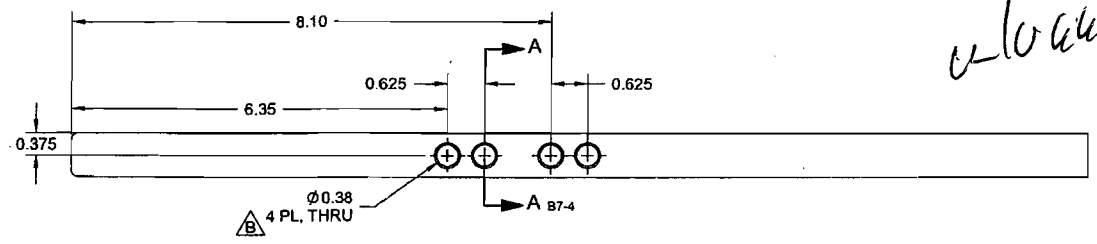
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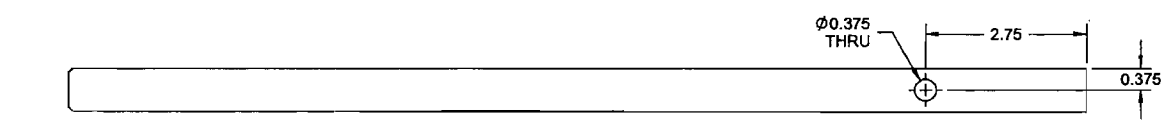
D4034-1 RIB



SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB

RELEASED
2011-01-10

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 4 OF 4
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